

Work Order ID 61876

Wednesday, September 08, 2010 2:43:35 PM



Page 1

Item ID:	D2330-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Frame					
Start Date:	9/8/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	9/13/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>M</i>	Date:	<i>10-9-08</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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100		0.00							
Large Fab		0.00							
Large Fab	Memo								
	1- Cut tube as per dwg D2330								
	2- remove identification marks and deburr								

SM 10/09/08 (2x)

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Sidoslog

(+2)

120	Identify as per dwg & Stock Location:	0.00							
Packaging	<i>Basket call</i>	0.00							
Packaging	Memo								

SM 10/09/08 (2x)

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Item ID: D2330-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 9/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/09 *[Signature]*
MF
10-9-8

Picklist Print

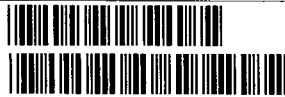
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Page 1

Work Order ID: 61876

Parent Item: D2330-5

Parent Item Name: Frame



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065 		Purchased	No			100	f	1,161.595	2.88	6.063158			
304 SQ Tube .75x.75x.065W													

MS 10/09/08 @ 2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	1118.3049	
112398	0	
114482	1.4628	
115494	536.8421	
115593	580	
WA	43.290385	
114520	11.363385	
115274	31.927	

6.063

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

G

G

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61879

010-9-05

RELEASED
01/01/06

NOTES:

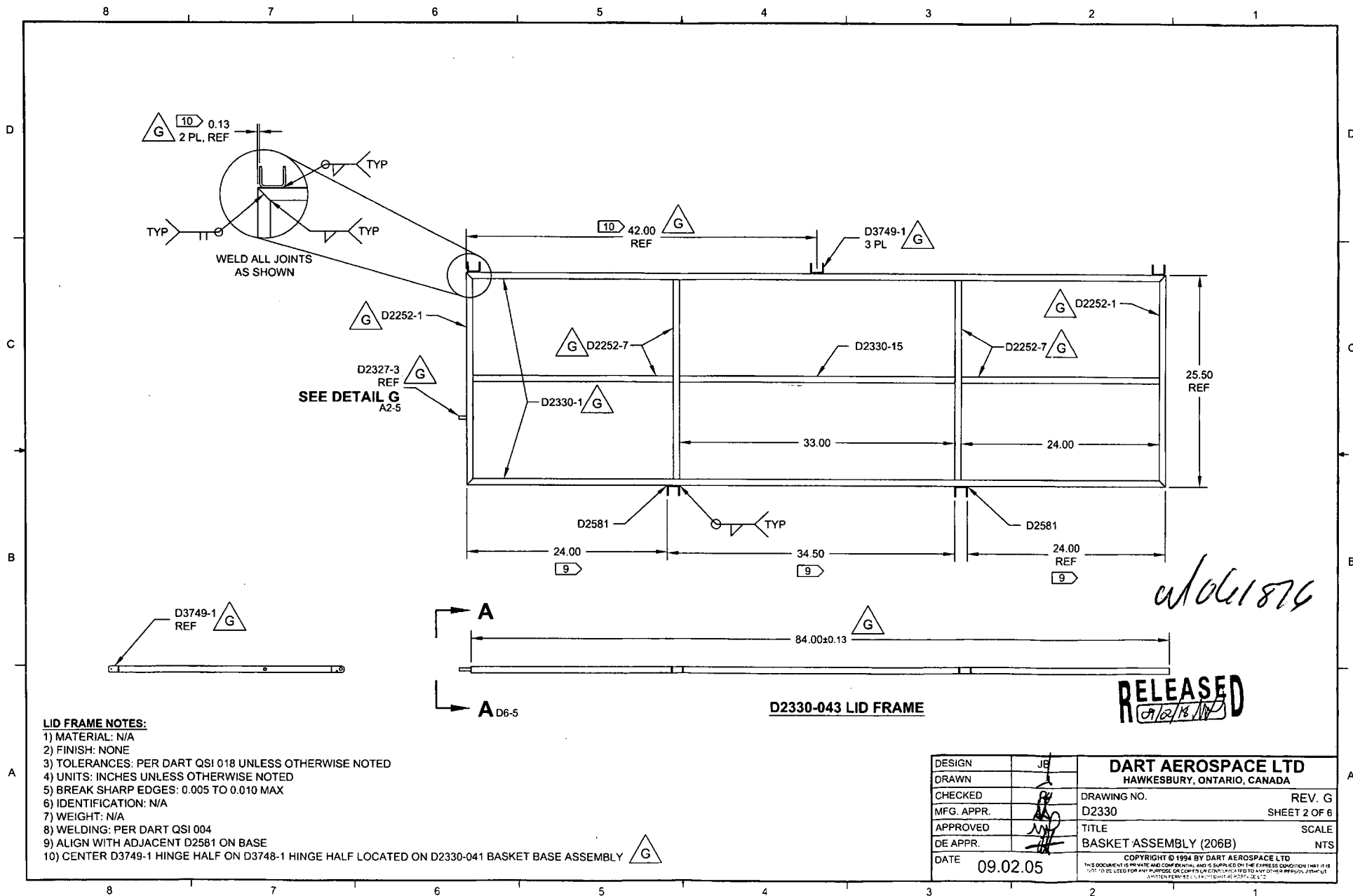
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

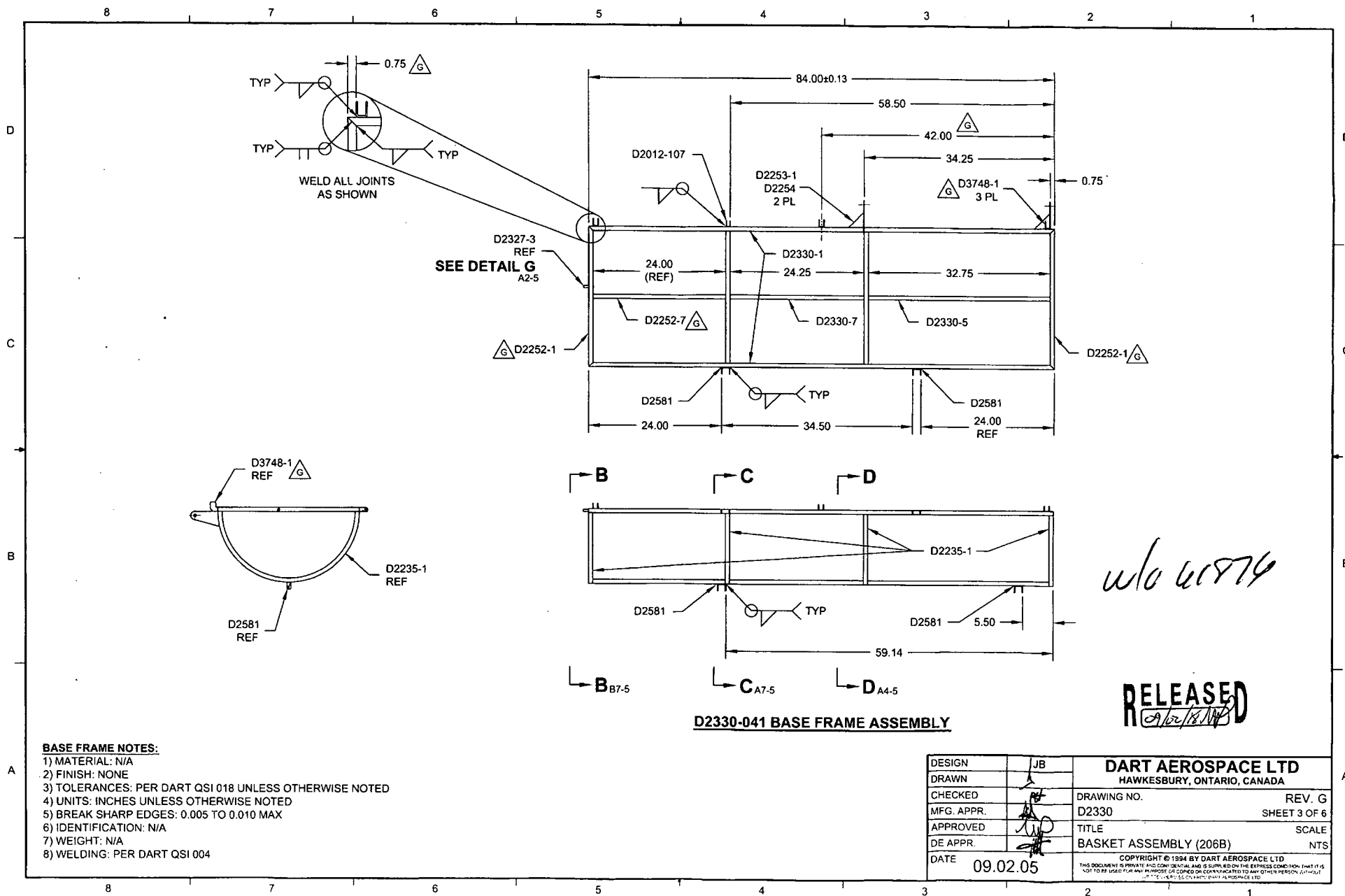
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2332-1/3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/9-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JIB		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

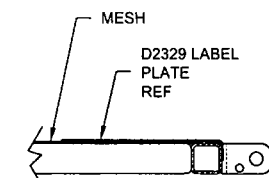
DRAWING NO. REV. G
D2330 SHEET 1 OF 6
TITLE SCALE
BASKET ASSEMBLY (206B) NTS

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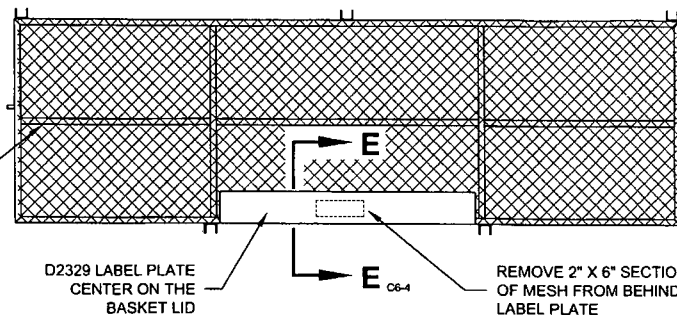


8 7 6 5 4 3 2 1

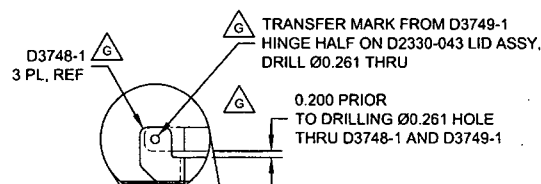


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME

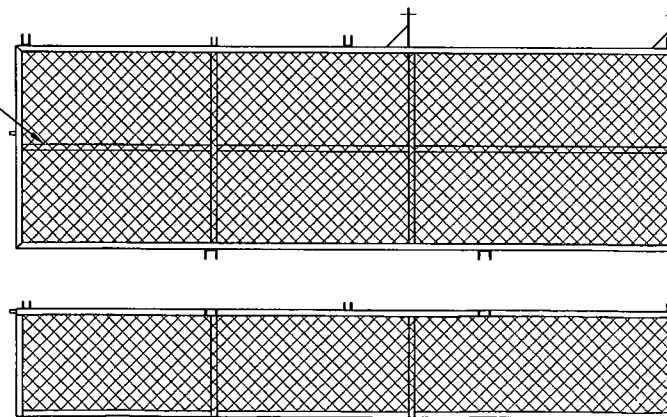


D2330-043 LID ASSEMBLY



D2330-043
REF

TRIM MESH LOCALLY
AS REQUIRED



D2330-041 BASE ASSEMBLY

ASSEMBLY NOTES:

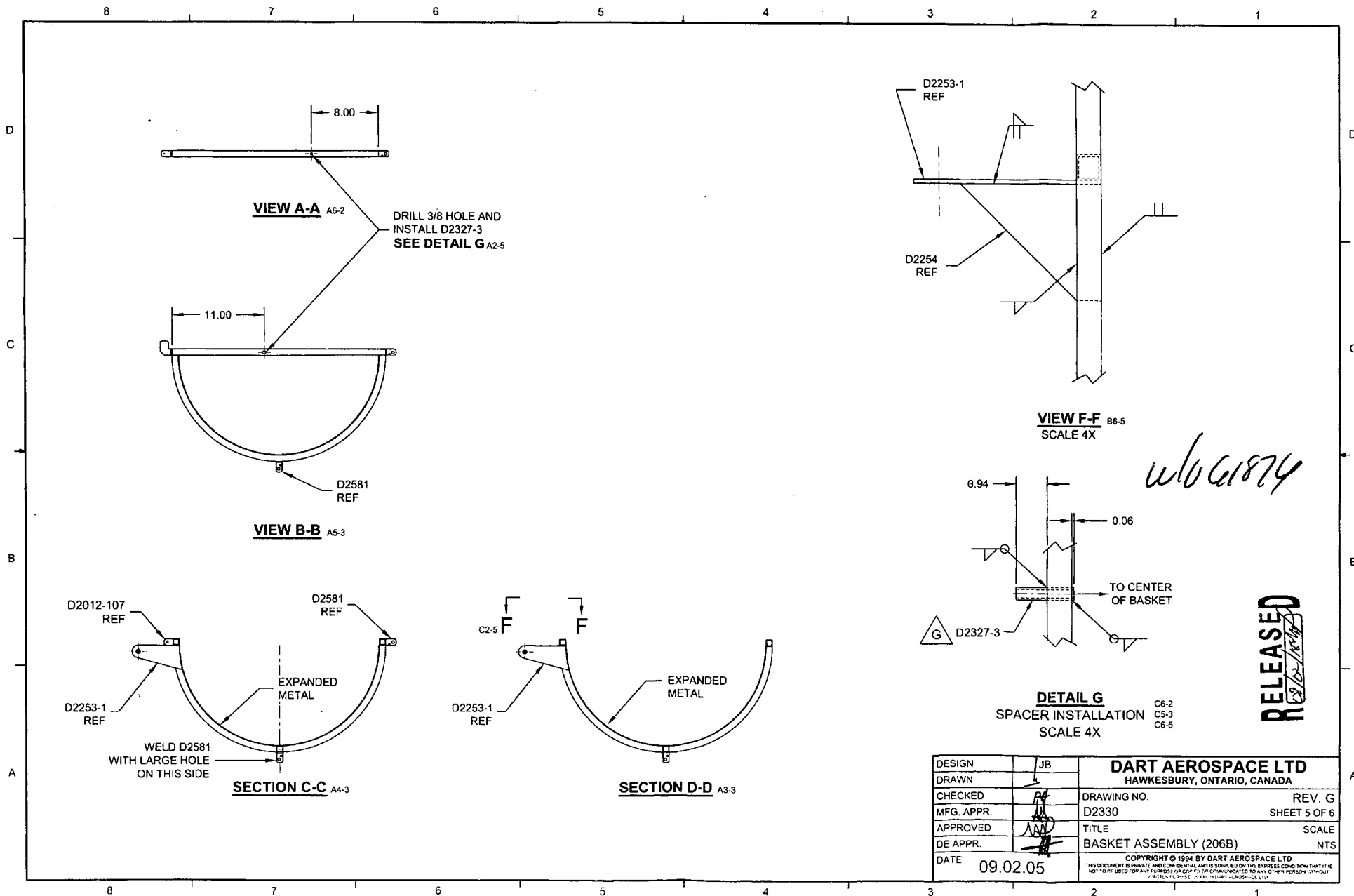
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

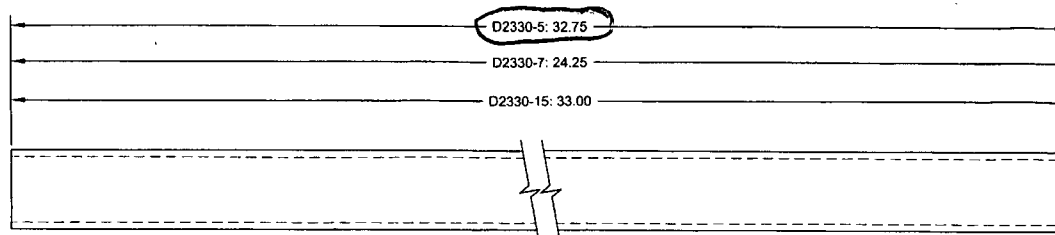
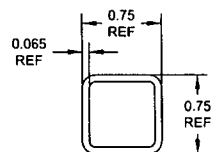
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

w/o 61874

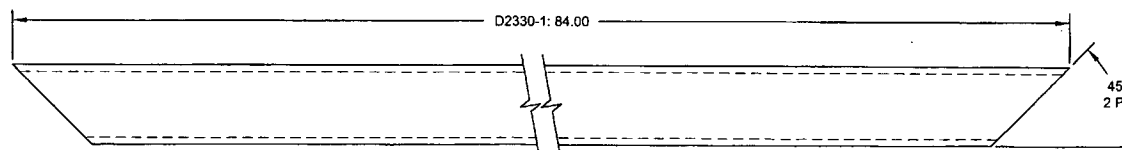
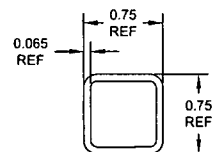
RELEASED
9/12/18

8 7 6 5 4 3 2 1





D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

W1060874

RELEASED
9/2/18

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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